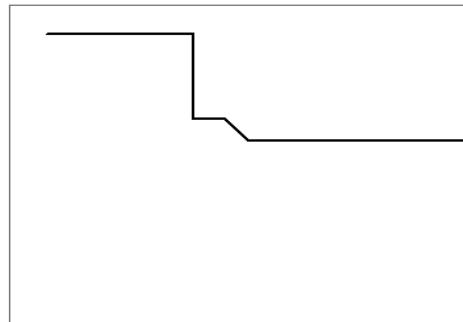


Profiled milling cutter

A02-001

This is an example of profiled milling cutter which is used for processing bath taps and water valves. The carbide plates are soldered on plate holder and are exchangeable. After grinding the rake surface, the profile is preground and finished. A small margin of about 0.05mm is ground using cylindrical profile grinding.



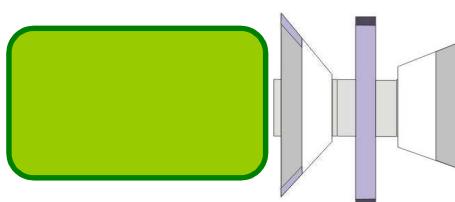
1. Cycletime for Production

Workpiece:	Diameter 36 mm, Z 2, Step profile D19-D36mm Material CARBIDE					
Operations	Probe	Flute 1	Gashing	Prf Pgnd	Prf fin	Prf Cyl
Feed [mm/Min]	2000	60	100	30	30	4
Power [kW]		3	2	1	1	1
Cutting speed [m/s]		20	32	20	20	20
Used wheels		1	2	3	3	3
Grinding time [s]	27	180	50	240	180	480
Total cycle time	19 Min 17					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64



2 1 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders: NORMA / ARIES
Control: Fanuc 310i
Accessories:
Responsible engineer: SIW. 23.5.13

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

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